

Date: Tuesday, 15/08/2006 7:19:52 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT WELDMENT ASS'Y
Job Number : 28185	
Estimate Number : 10564	
P.O. Number : <i>N/A</i>	Part Number : D34433
This Issue : 15/08/2006 S.O. No. : <i>N/A</i>	Drawing Number : D3443 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 27795	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 31/08/2006 Qty: 8 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev: A 05.11.14 New issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0 M304R1500



Comment: Qty.: 0.2500 f(s)/Unit Total : -2.0000 f(s)

Batch : M19052

[Signature] 06/08/18

2.0 HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-TURN AS PER FOLIO FA588 & DWG D3443

FOLIO REV: *N/A* *Machined Manually*

DWG REV: *B*

2-DEBURR AS REQUIRED

[Signature] 06/08/21

8

3.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

[Signature] 06/08/21

8

4.0 HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA588 Rev: *AA* & Dwg D3443 Rev: *B*

2-Deburr per dwg D3443

J.F. Airl 06/09/08

(5)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/09/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/09/11	4/0	I Index the fixture 90° insted of 180° Tool came in on the wrong side.	 06/09/11	1 part + scrap. destroy. No replace.	J.F. 06/09/11	 06-09-11	 06/09/11	 06-09-11
06-09-11	4/0	2 parts scrap Slot machi- neel crooked by .040" Parts not placed properly.	 06/09/11	Scrap destroy: No replace.		 06-09-11	 06/09/11	 06-09-11

NOTE: Date & initial all entries

Date: Monday, 11/09/2006 12:48:49 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASSY

Job Number: 28185

Part Number: D34433

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

7.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Drill hole as per Dwg D3443.

AA 06/09/11

5

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

AA 06/09/11

5

9.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SB 06.09.11

5

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

51436

AB 06/09/11

5

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/09/12

5

Job Completion



W 06.09.12

Date: Tuesday, 15/08/2006 7:19:52 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 28185

Part Number: D34433

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F./mL 06/09/08

(5)

6.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Drill hole as per Dwg D3443.

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

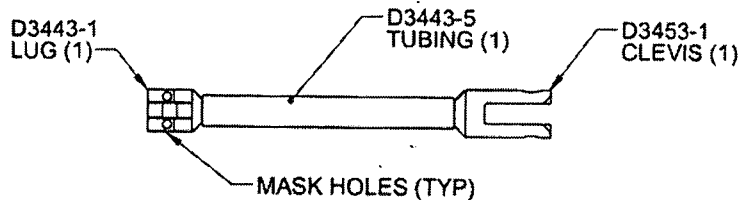
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

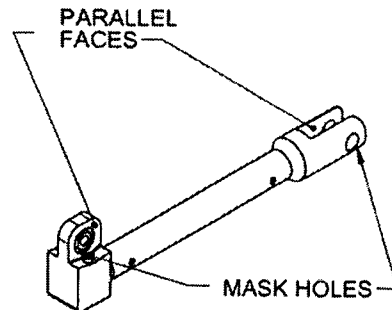
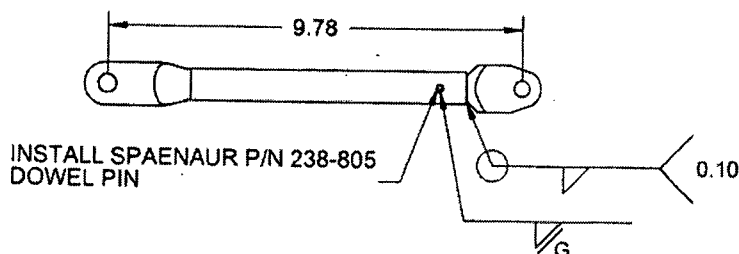
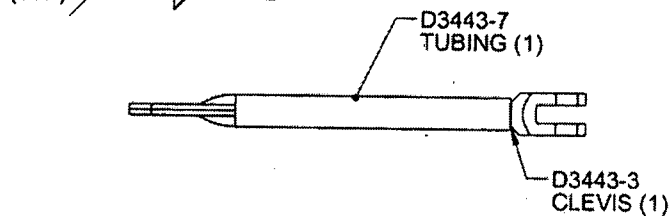
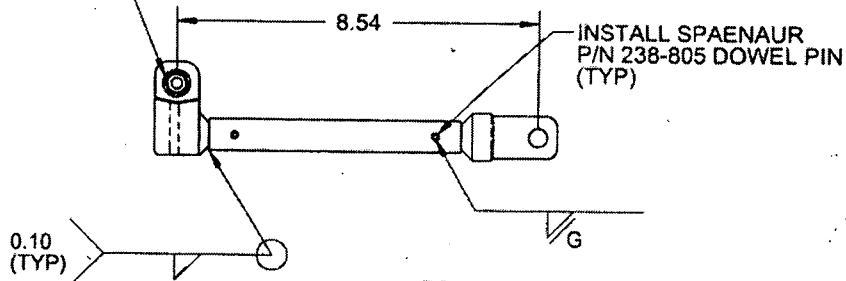
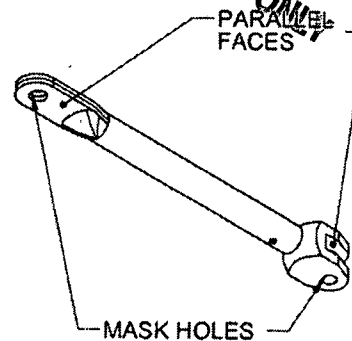
NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3443	REV. B SHEET 1 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY SCALE 1:4		
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & $\phi 0.125$ WAS #30	

RELEASED05.12.09 *[Signature]*

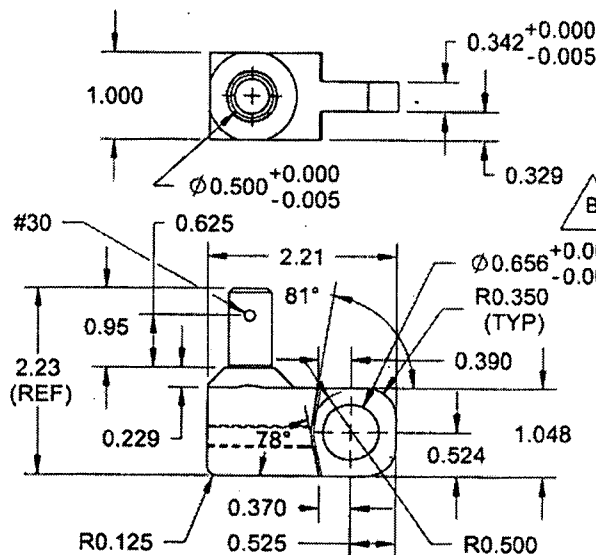
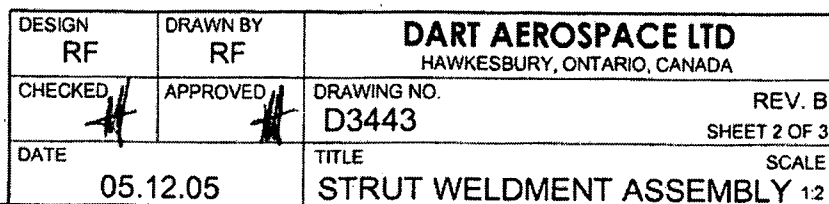
PRESS FIT McMASTER-CARR P/N 63215K32
BALL JOINT BEARING AFTER POWDER COAT

**D3443-041****REFERENCE ONLY****D3443-043****NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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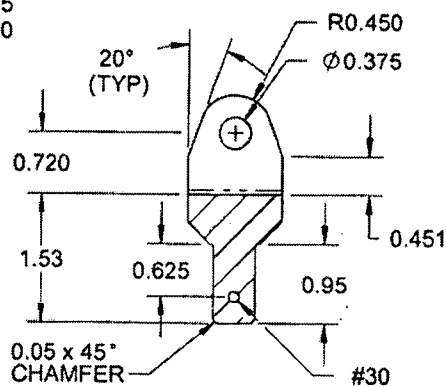
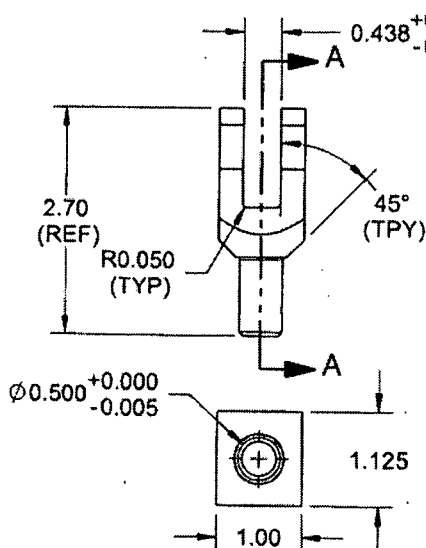
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D3443-1 LUG

D3443-1 NOTES:

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)



SECTION A-A

D3443-3 CLEVIS

D3443-3 NOTES:

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

GENERAL NOTES:

- GENERAL NOTES:**
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

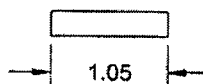
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3443	REV. B SHEET 3 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY SCALE 1:2		

$\phi 0.210^{+0.005}_{-0.010}$



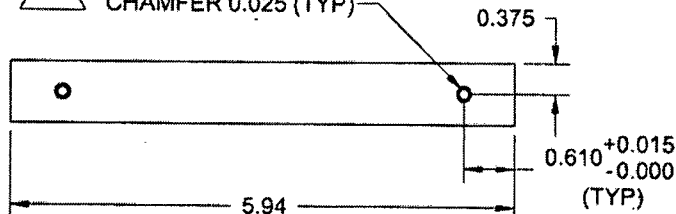
D3443-9 PIN

D3443-9 NOTES:

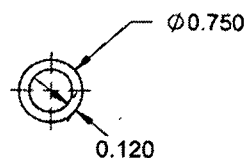
- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES



DRILL $\phi 0.125$ THRU
CHAMFER 0.025 (TYP)

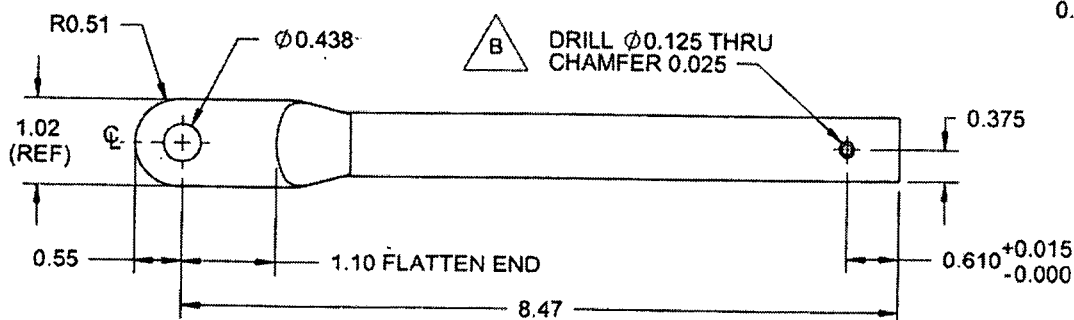
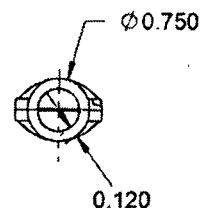
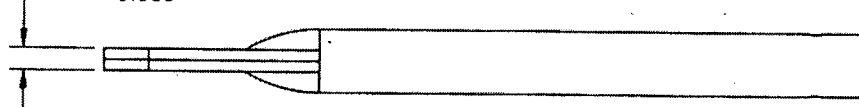


RELEASED
05.12.09



D3443-5 TUBING

$0.260^{+0.000}_{-0.030}$



D3443-7 TUBING

D3443-5/-7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.7500W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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D3065-5DART AEROSPACE LTD		Work Order: 28185
Description: Clevis		Part Number: D3443-3
Inspection Dwg: #D3443	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.70	+/-0.030	2.701	✓			
0.95	+/-0.030	.950	✓			
Ø0.500	+0.000/-0.005	.499	✓			
20°	+/-0.5°	20°	✓			
R0.450	+/-0.010	R0.448	✓			
Ø0.375	+0.006/-0.001	Ø0.378	✓			
0.451	+/-0.010	0.448	✓			
0.625	+/-0.010	.625				
1.53	+/-0.030	1.531	✓			
0.720	+/-0.010	0.726	✓			
0.05 x 45°	+/-0.5°	.05 x 45°	✓			
45°	+/-0.5°	45°	✓			
1.00	+/-0.030	1.004	✓			
1.125	+/-0.010	1.130	✓			
0.438	+0.005/-0.000	0.438	✓			
R0.050	+/-0.010	R0.050	✓			
Ø.129	+0.005 -0.001	.129				

Measured by: AS / gml	Audited by: J.G / J.F / JS	Prototype Approval:	N/A
Date: 06/08/21 / 06/09/21	Date: 06/08/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.28	New Issue	KJ/JLM	